

TOPY SPLIT











Date: Tuesday, 05/06/2007 11:37:11 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER
Job Number	: 32752		
Estimate Number	: 10980		
P.O. Number	: <i>N/A</i>	Part Number	: D2808
This Issue	: 05/06/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2808 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : MACHINED PARTS	Drawing Revision	: A1
Previous Run	: 28600	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 05/06/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	<i>40</i> Um: Each
Comment	: Est Rev:D 02.03.07 Now turned in house NG		

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R0625	6061-T6 Round Bar .625"
		
	Comment: Qty.: 0.0557 f(s)/Unit Total : 2.2260 f(s) 6061-T6 Round Bar .625" (M6061T6R0625) Batch: <i>M103857</i>	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
		
	Comment: HARDINGE CNC LATHE SMALL 1-Turn as per Folio FA205(Mesure D3387 Bracket .507" Dia for Proper press-fit) 2-Deburr	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK
		
	Comment: SECOND CHECK	
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		
	Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1	
5.1	<i>Powder Coat white</i> <i>60 per QSI 005 4.3</i>	

07-06-07

FXL
01/04/04
FXL

01/06/06

01/06/08

(40)
(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 07/06/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

P07/6/8 40

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST50

P07/6/8 (40)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(40) D07/6/8

Job Completion



U 87-0608

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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QA: N/C Closed: _____ Date: _____

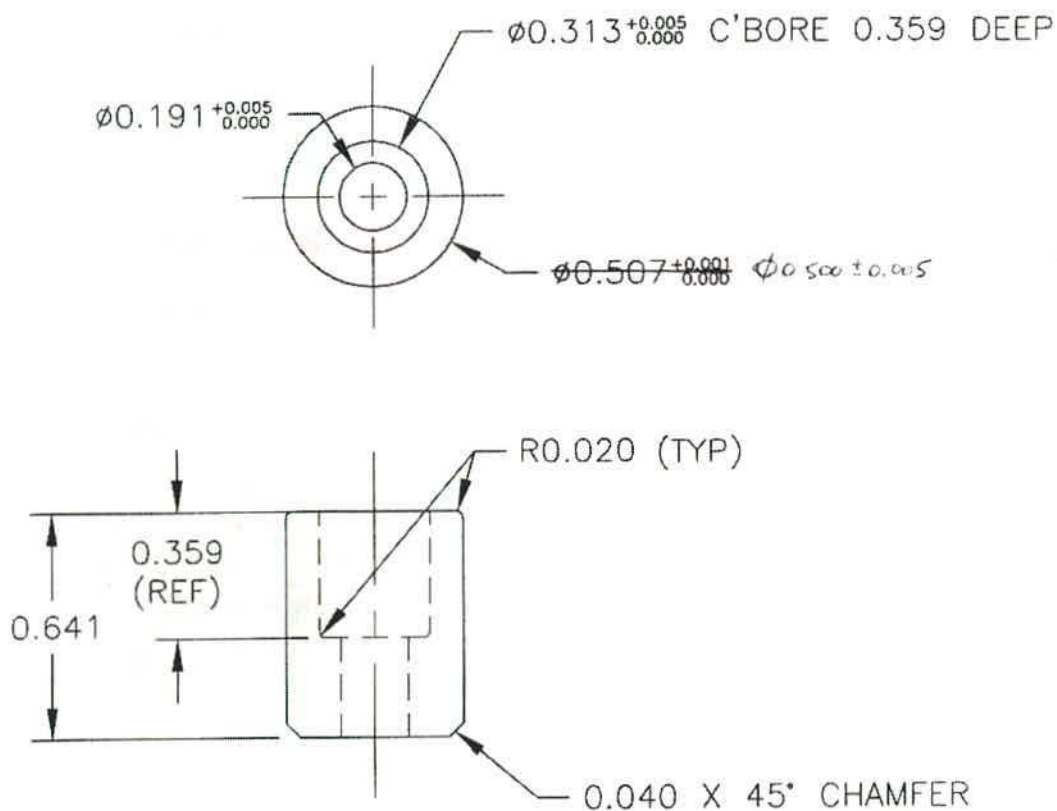
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NOTE: Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2808	REV. A SHEET 1 OF 1
DATE 00.11.07		TITLE SPACER	SCALE 2:1
A	00.11.07	NEW ISSUE	
A1	CP 01.04.26	ADD POWDER COAT ; $\phi 0.500$ WAS $\phi 0.507$	

RELEASED
00.11.13



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020

MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT WHITE (435.1) OR GREY SANDTEX (435.6) OR BLACK SANDTEX (435.7)
OR GREEN SANDTEX (435.8) PER DART QSI 005 4.3

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